

Date: Wednesday, 8/15/2007 7:56:14 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	FLOOR PROTCTOR AFT LH		
Job Number	33899	Part Number	D32813		
Estimate Number	11228	Drawing Number	D3281 REV B		
P.O. Number	N/A	Project Number	N/A C PRELIMINARY		
This Issue	8/15/2007	S.O. No.	N/A		
Prsht Rev.	NC	Type	R&D THERMOFORMING		
First Issue	N/A	Material	B		
Previous Run	30660	Due Date	8/22/2007		
Written By	<i>Jean-Luc Menard 07-08-07</i>				
Checked & Approved By					
Comment	Est Rev A 04.07.01 New issue KJ/JLM Est Rev B 07.08.07 Thermoform in house DL				

## Additional Product

Job Number:		
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Seq. #:	Machine Or Operation:	Description:
1.0	F6002 701	lexan black


 POSITIVE RECALL

Comment: Qty.: 4.3600 sf(s)/Unit Total : 43.6000 sf(s)  
 lexan black .125"



Material Batch # M103735 

M105952 

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING		
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Comment: HAND FINISHING THERMOFORMING

*Wk. 07/08/20 PRO-  
 Sh. 07/10/29 R10*

1) Cut Blanks

3.0	THERMOFORMING	THERMOFORMING MACHINE		
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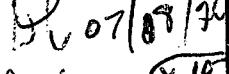
Comment: THERMOFORMING MACHINE

*Wk. 07/08/20*

Thermoform as per Dwg. D32811 and Folio FTA 009

*Sh. 07/10/30 R10*

Dwg. Rev. B  
 Folio Rev. B

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*Sh. 07/10/30 R10*

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTCTOR AFT LH

Job Number: 33899

Part Number: D32813

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 HAND FINISH TH



HAND FINISHING THERMOFORMING



PTO →

Comment: HAND FINISHING THERMOFORMING

DL 07/10/30 x10

1) Trim to Finished Dimensions

BB 07-10-05 (18)

6.0 QC2



INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

DL 07.10.05 (18)

2) Check dimensions to ensure conformity to drawing tolerances.

DL 07.10.30 x10

7.0 QC5



INSPECT WORK TO CURRENT STEP



POSITIVE  
RECALL

5/11/09

Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1



PACKAGING RESOURCE #1

ENGINEERING APPROVAL 07/11/06



Comment: PACKAGING RESOURCE #1

DL 07/11/09 (10)

9.0 QC21



FINAL INSPECTION/W/O RELEASE



DL 11/11/09

Comment: FINAL INSPECTION/W/O RELEASE

DL 11/11/09

Job Completion



POSITIVE RECALL  
EFFECTIVE 07/08/09 AUTH 4  
RELEASED 07/11/09 DATE 07/11/06



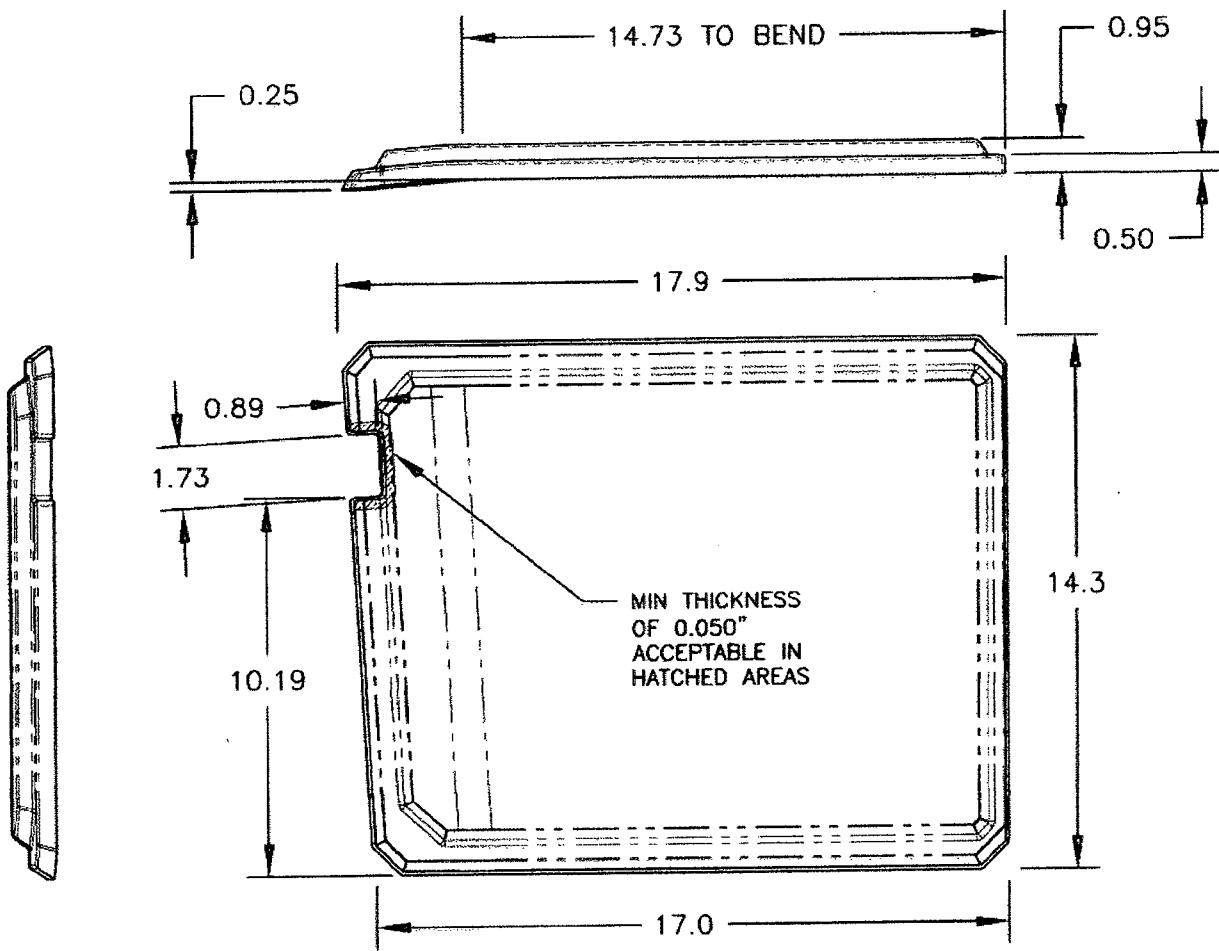
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3281
DATE	05.11.25	TITLE FLOOR PROTECTOR

REV. B

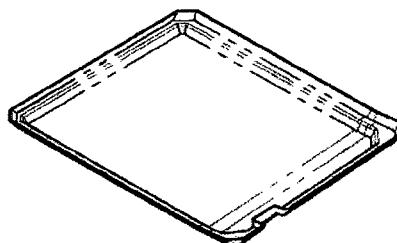
SHEET 3 OF 3

SCALE

1:5



RELEASED  
05.12.01. *[Signature]*



#### D3281-3 FLOOR PROTECTOR AFT LH (SHOWN)

#### D3281-4 FLOOR PROTECTOR AFT RH (OPPOSITE)

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
- 2) THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 3) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

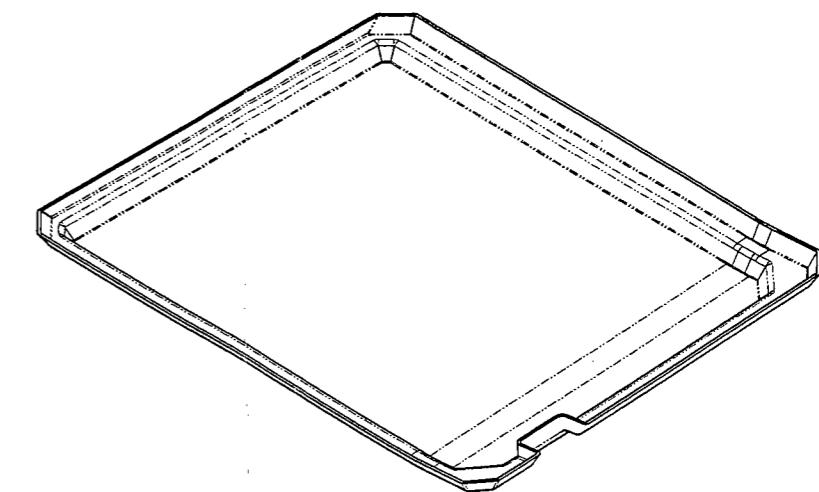
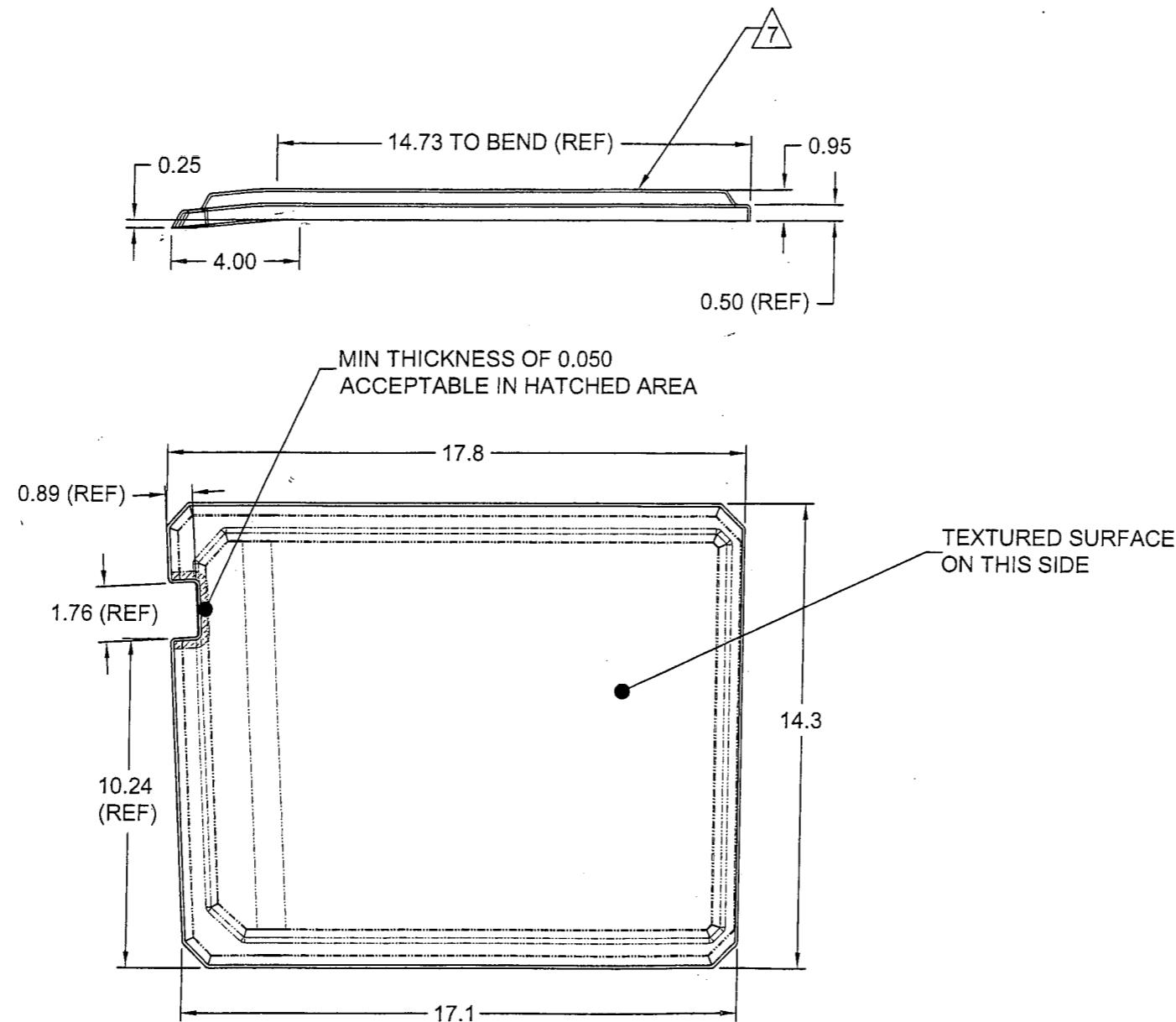
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.10.04	S.O	TRIMMED 0.25" EXTRA OFF TOP SURFACE ON OUTBOARD EDGE	10/04 OT	ACCEPTABLE ENSURE PARTS SHIPPED WITH W/O 33900.				

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33899

D3281-3 FLOOR PROTECTOR  
(D3281-4 OPPOSITE)

**PRELIMINARY ISSUE**

LE 07.10.09

D3281-3/4 NOTES:

- 1) THERMOFORM WITH MOLD D3281-3T1 FOR D3281-3 AND D3281-4T1 FOR D3281-4 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK  
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3/4" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

DESIGN	<i>QP</i>	<b>DART AEROSPACE LTD</b>
DRAWN	<i>LE</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>LE</i>	DRAWING NO.
MFG. APPR.	<i>LE</i>	REV. C
APPROVED	<i>LE</i>	SHEET 3 OF 3
DE APPR.	<i>LE</i>	SCALE
DATE	07.10.09	NTS
FLOOR PROTECTOR		
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.10.25	6.	8 parts <del>scratches</del> & formed. material Batch. M103735	WD 07/10/25	Scrap & Replace.	07/10/25 W.H.	✓ 07/10/31	DB 07/11/05	✓ 07/11/31

NOTE: Date & initial all entries

DART AEROSPACE LTD	WORK ORDER:	33899
Description: R44 Floor Protector Rear LH	Part Number:	D3281-3
Inspection Dwg: D3281	Rev: B	Page 1 of 1

C Preliminary.

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

(Step 4) Thermoforming  
Visual Inspection Sign-off

Description	Initials
Inside Radii less than 3/16" go/no go	WJ
Acceptable shape definition	PK
Acceptable texture retention	DT
Free of visual flaws (bumps, cracks, voids, etc.)	OG

(Step 6) Trimming  
FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3281 Rev. ~~B~~ and record below  
C Preliminary.

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.1	.1	17.1	✓		TAPE	
17.8	.1	17.75	✓		TAPE	
14.3	.1	14.25	✓		TAPE	
10.24	.030	10.25	✓		TAPE	
.95	.030	.958	✓		TAPE	Acceptable
4.0	.030	3.125	✓		CAL	WRONG DIM ON Dwg
						LE
						07.11.01

Measured by: <i>jh</i>	Audited by: <i>ds</i>	Prototype Approval: <i>LE</i>
Date: 07/10/31	Date: 07/10/31	Date: 07/11/01

Rev	Date	Change	Revised by	Approved
		New Issue		